

Work Order ID 152109

Wednesday, October 19, 2016 3:29:04 PM

152109

Page 1

Item ID: PB67-43001-337

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Stop Plate

Start Date: 10/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-69

Date:

OCT 20 2016

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr**Revision Nbr**

B67-43001

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: CProg Rev: C

****grain direction along 5.2826" ****

2-Deburr if necessary

2PR 10/10/21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2PR 10/10/21

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Page 2

Item ID: PB67-43001-337

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Stop Plate

Stop

NS2

Start Date: 10/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

(2)

OCT 21 2016

DAS
9
9-89

130

Bend as per dwg
NC BRAKE

0.06

130

Brake NC

Memo

0.02

Brake NC

DAS
30
9-89

(2)

NOV 29 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.01

Quality Control

2

DAS
38
9-89

NOV 29 2016

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Page 3

Item ID: PB67-43001-337

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stop Plate

Start Date: 10/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: **M2220** 0.00***150***

Packaging

Memo

0.00

Packaging

LOCATION: WA003

2 **DAS**
6 **NOV 3 0 2016**
9-89

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.03

Quality Control

DAS
21 **NOV 3 0 2016**
9-89**DAS**
21 **NOV 3 0 2016**
9-89

Picklist Print

Wednesday, October 19, 2016 3:29:03 PM

Page 1

Work Order ID: 152109

152109

Parent Item: PB67-43001-337

PB67-43001-337

Parent Item Name: Stop Plate

Start Date: 10/14/2016

Required Date: 10/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-23 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased		No		100	sf	42.5000	0.0653	0.137474			

M6061T6S.090

6061-T6 .090 Sheet

PR 10/10/21

Location

Loc Qty

Loc Code

MAT020

42.5

M133699

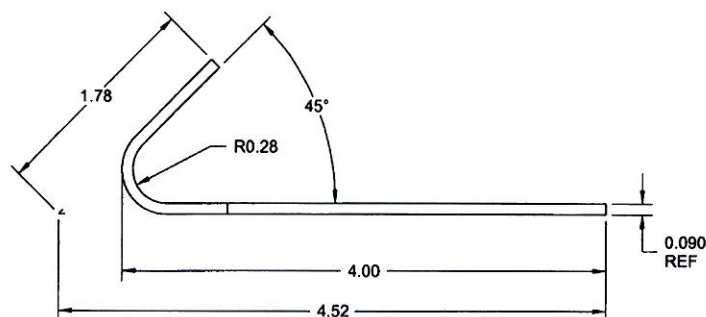
2.5

M134147

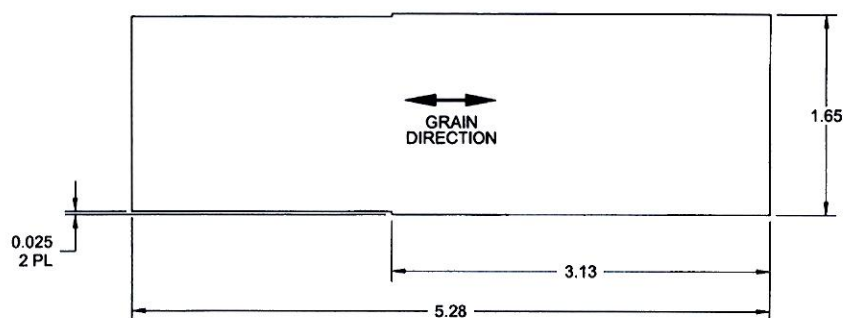
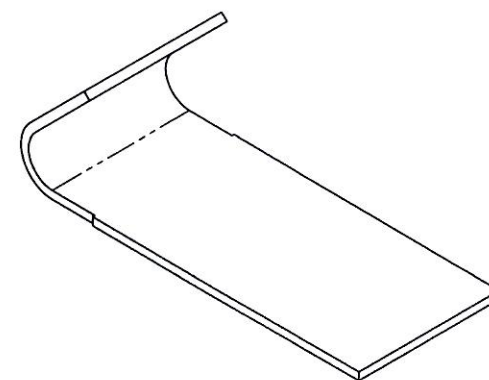
40

M133147

0.13



B67-43001-337 STOP PLATE
(MAKE FROM B67-43001-337F)



B67-43001-337F FLAT PATTERN (1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
152109 MLC
10-10-20

RELEASED
2009-09-24
AMP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.090
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 44 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.12
REV.		DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-337 TITLE STOP PLATE COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. C	
DRAWN			SHEET 1 OF 1	
CHECKED	AS		SCALE	
MFG. APPR.			NT	
APPROVED			DATE	
DE APPR.	N/A	09.03.12		

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